

5/18

DART AEROSPACE LTD	Work Order:	22934
Description: 206 Extrusion Bending	Part Number:	D2620
Drawing: D2620 Rev. B	Qty:	35

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HJ	05.04.20	35
2	LG	Bend D2600-1 extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio FT008 Batch B20534	BE	05-05-4	35
3	LG	Cut Fwd end of tube as per Dwg D2620	BE	05/5/4	35
4	QC5	Inspect for Completeness on the W/O	DP	05/05/04	35
5	LG	Identify and Stock in LG Cell	DP	05/5/10	35
6	AC	Cost/Part: 29.44	AP	05/05/11	35
7	DC	Close W/O 29.25 Inspect Level 21	HJ	05.05.16	35

Rev	Date	Change	Revised By	Approved
A	97.12.03		BW	
B	98.09.09	Bending now in-house	KS	
C	99.06.04	Re-format, Added cut	DM	
D	02.07.26	Change Dwg to rev.B; Updated Location	RF	

RELEASED
02/08/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

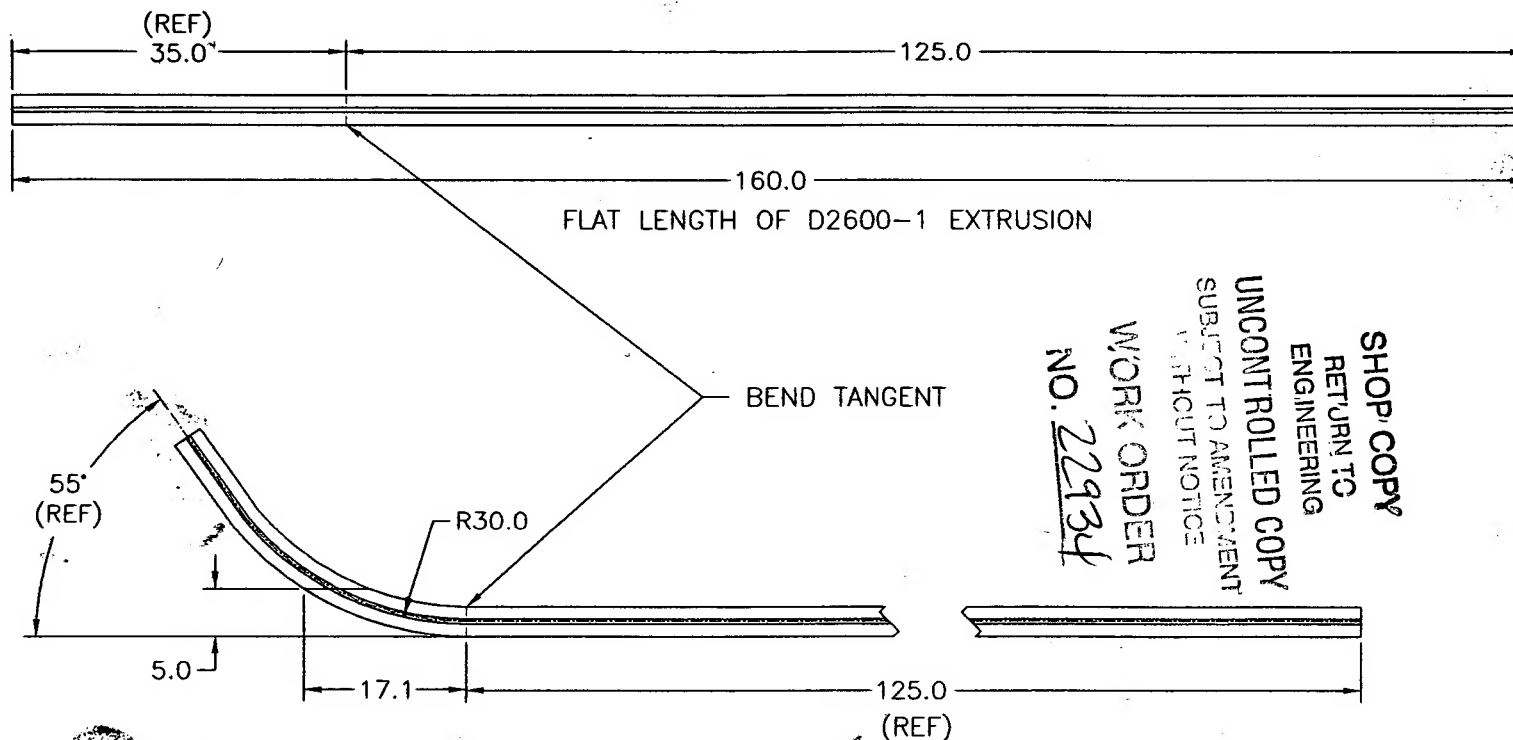
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	TITLE	SCALE
99.09.10	RF	206 SKIDTUBE BENDING CONTROL	1:20
CHECKED BY	APPROVED	DRAWING NO.	REV. B
DATE			SHEET 1 OF 1
A	97.11.07	NEW ISSUE	
B	97.09.10	UPDATE FOR IN-HOUSE BENDING	

RELEASED
44.04.15 DS

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 19, 2005
04:18 pm

Work Order No : 0022934
Project Name : D2620
Project For : WK518
Work Order Type : Main
Main WO Number :
House Part Number : D2620
Description : Bent 206 Skidtube
Manufactured : Yes
Amount Req'd : 35
Amount Done : 0
Start Date : 04-07-05
Est Finish Date : 04-28-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00